Work Order August-28-13 12:	r ID 106016 28:44 PM			*106	3016*						Page 1	
tem ID: E	22000-047	. 77.2 21	<u>.</u>	Accept	*N900	ก4ก	100	* s	etup Star	1.7	S1*	
ltem Name: A	Aspirator Assy - Defro	st							Stop	, *N	S2*	
Start Date: 9	/02/13 Start	Qty: 2.00	*2*		Cust Item	ID:						
Required Date: 9	/02/13 Req'd	l Qty: 2.00	*2*		Customer:							
Reference:							_	_	. Cı			
Approvals:	Process Plan: 💆	mr.	Date: 15~8	76 Tooling:	D	ate:	-	F	Run Star	171	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			Stop	` *N	R2*	
Sequence ID/ Work Center ID	Opera Descri		· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr	Revision N	br										
D2000-047	Rev A1											
160				0.00				~				
100	Large F			0.00				(2)_	E	13-	8-28	
Large Fab Large Fab				0.00 tor D2000-109 per dwg D200 D2000-109 per dwg D2000	00							
110	QC9- lı	nspect visual per	QSI004- Fusion Weld	s 0.00								
110							_	9)_B1	DB-29	3 _ PD	
QC		Memo		0.00						<u> </u>		
Quality Control												
120	Outsou	rce process-Ano	dize per QSI017 4.1.10	0.00				Λ ⁽	j .	Oln :		
120 Outsource4		Memo		0.00 \$7)0	. 21136		-		L 1311	0 <u>XI Q C</u>) (3) _	

Outsource process - Anodize

Anodize Matte Black per QSI 017

NCR:	Yes	/	No

WORK ORDER NON-CONFORMANCE / UPDATE

			" · · ·
	DQA:	Date:	· ·
	QA Closed:	Date:	•
n F	PARTMENT		
	Pro	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
	Sign & Date	Verification	QC Inspector
: :			

										QA Closed:	Da	ite:	
Work Order	r:	•			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part No. Scrap Use-as-it NCR No. Work Order Update					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	_	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	П	nitial	Act	tion	Sign &			·
Cause	Dat	e Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	on	QC Inspector
Doc/Data	-	<u> </u>			······································								 :
Equip/Tooling		ĺ											
Operator													
Material		İ]		- [
Setup													
Other		1						ļ				İ	
Process		-											
Supplier													
Training			\			ļ							
Unapproved		<u></u>				<u></u>		<u> </u>					
						AUL	T CATE	GORY	·				<u> </u>
Landin	g Gear			_	General		,		<u></u>	7			
	Bendi	_			Bend	_	Grain		 	Ovalized		-	ressure/Forced
	_	Not Conce	ntric to	o/s	BOM/Route	\perp	Hardwa		<u> </u>	Over/Under		-	emperature/Cure
<u> </u>	Crack		-	<u> </u>	Broken/Damaged		4 '	ion incomplete		Part Incorre		$\boldsymbol{\vdash}$	/eld
	_	ed/Crimped		\vdash	Burrs	\vdash	4	ions Incomplete/	Unclear	Part Lost/M	-	Шw	rong Stock Pulled
	Cuffs			<u> </u>	Contamination	<u> </u>	Mainte			Part Moved			
-	Heat			<u> </u>	Countersink	<u> </u>	Mislabe			Positioned V		\Box	- 6
		ction Strip in	1 Tube	<u> </u>	Cut Too Short	\perp	Misrea	1	<u> </u>	Power Loss/	Surge		ther
		s in Bend			Drill Holes	_	Offset						
	_ `	e Waves in		n	Drawing	<u> </u>	4	Calibration					· · · · · · · · · · · · · · · · · · ·
	 -	ng Sequence		<u> </u>	Finish	 	4	Sequence	٠.	-			·
	Wave	/Twist in Tu	be		Folio		Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2 August-28-13 12:28:44 PM Accept Setup Start D2000-047 Item ID: **Revision ID:** Stop Aspirator Assy - Defrost Item Name: Start Qty: 2.00 **Start Date:** 9/02/13 Cust Item ID: Required Date: 9/02/13 Req'd Qty: 2.00 Customer: Reference: Run Process Plan: Tooling: Date: Approvals: Stop SPC (Y/N): Date: Date: Tool # Plan Reject Accept Reject lnsp. Sequence ID/ Set Up/ Tool ID Operation Qty Number Stamp Run Hours Code Description Work Center ID Receive & Inspect for Damage & Mat'l Certs 0.00 130 *120* 0.00 Packaging Memo Packaging DAS 27 140 QC6- Inspect dimensions to drawing *140* QC Memo Quality Control 0.00

150

150

Large Fab

Large Fab

Large Fab

Memo

Assemble screen & washer as per dwg D2000

0.00

											DQA:	Date	::
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR			,		
		•							_		QA Closed:	Date	:
Work Orde						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	٠ No.					Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Prod. Eng. Coor. Use-as-is Thermoforming Finishing Rec/Store/Packaging rder Update Large Fab Composite Supplier					Engineering Quality Other	
Root					Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC inspector
Doc/Data											_		
Equip/Tooling													
Operator			}										
Material			1				1						
Setup			1				1						
Other													
Process			1								i		
Supplier			l								j		
Training		ı	l		:					-			
Unapproved													
						F	AUI	LT CATE	GORY				
Landi	ng G	ear				General		_			_		
,		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa	re]Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct 🖊 🗌	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong	
		inspectio	n Strip in	Tube		Cut Too Short		Misread	Ī	Γ-	Power Loss/	Surge	Other
	Г	Rinnles in	Rend			Drill Holes		Offset			_	_	

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Orde		6016		*106	റ 1	6*	·· <u> </u>	- - - -	_ 	-:		Page :
Item ID: Revision ID:	D2000-047		-	Accept	*	1900	040	100)* s	etup Sta	1 1	S1*
Item Name: Start Date: Required Date: Reference:	Aspirator Ass 9/02/13 9/02/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*			Cust Item I Customer:	D:				· "IXI	S2*
Approvals:		an:					nte:		R	tun Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part comp Memo	leteness to step on W/O	Set Up/ Run Hours 0.00 DAS 27 0.00 9-89	6	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & S Memo	tock Location:	0.00					2_		As)	, p.e. Ne New

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

180

Quality Control

13/9/9/9 13-9-6

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											, ,
									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP	DATE	QA Closed:	Date:	·
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											

FAULT CATEGORY

General

Pressure/Forced Ovalized Bend Grain Bending Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Part Incorrect Weld . Cracks Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Mislabeled Heat Treat Countersink Other Misread Power Loss/Surge Cut Too Short Inspection Strip in Tube Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Finish Out of Sequence Turning Sequence Wave/Twist in Tube Folio Outside Dimensions

1.1

Landing Gear

Picklist Print

August-28-13 12:28:43 PM

Work Order ID:

106016

Parent Item:

D2000-047

Parent Item Name:

Aspirator Assy - Defrost

Start Date: 9/02/13

Required Date: 9/02/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

1PP C02.03.05Revised Pick ListSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2000-043		Manufactured	No		- · - ·	100	Each	20.0000	1	\mathcal{A}_{-1}^{2}	3-8-	29	
				Location ST002	34>	Loc Oty 20 20	<u>L</u>	oc Code		2			
D2000-109 Aspirator		Manufactured	No			100	Each	9.0000	l ——	\mathcal{Q}^2	<u> </u>	<i>a</i> 9	
				Location Mezz.	D	<u>Loc Oty</u> 9 9		oc Code		7			
D2000-111 Aspirator		Manufactured	No	Location		100 Loc Oty	-	6.0000 oc Code) 	_EZ	13-8	<u> 39</u>	
D2714 Washer	,	Manufactured	No	Mezz.	<u> </u>	6 6 100		225.0000		\mathcal{A}^{2}	13 <u>-8-</u>	29	
				Location Mezz	<u>a</u>	<u>Loc Oty</u> 225 225		oc Code				r	
D3047-1 Screen Vent		Manufactured	No			110	Each	56.0000	1	E _2/.	3-8-2	9	
				Location ST024	6	<u>Loc Oty</u> 56 56		oc Code		<u></u>			

										DQA:	Dat	e:	
NCR: Y	es / No)			WORK ORDER NON-O	ONF	ORN	MANCE / UPDATE		·		_	¥
	· · · · · · · · · · · · · · · · · · ·									QA Closed:	Dat	ie:	
					DISPOSITION			AGAINST	DE	PARTMENT,	PROCESS		
Work Orde	er:				1	, I			_	7	آمدان داد داده	\neg	
					Rework	 		Skid-tube Crosstube	_	0	Water Jet	긕	Engineering Quality
Part N	NO				Scrap Use-as-is	╎ ┃╻		Machining Small Fab	_	4	d. Eng. Coor. e/Packaging	{	Other
NCR N	io.				Work Order Update	''		Large Fab Composite	⊢	NEC/3to	Supplier	ᅥ	
14CIV IV	1 0.				Work order opdate	¹		composite	_	J	aabhua. [
Root				Descri	ption of work order update	Initi	al	Action		Sign &		\neg	
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	<u> </u>	QC Inspector
Doc/Data													
Equip/Tooling							İ						
Operator		1		<u> </u>								-	
Material				1									
Setup						ļ !							
Other			ł										
Process						ŀ	j						
Supplier				1			l					ľ	
Training]						1		-	
Unapproved			<u> </u>]				L <u> </u>				\Box	
					F	AULT C	ATE	GORY					
Landi	ng Gear				General					-			
	Bendir	g			Bend	Gr	ain		L	Ovalized		$\overline{}$	Pressure/Forced
	Centre	Not Conce	entric to	o/s	_BOM/Route	Ha	rdwa	re	L	Over/Under	tolerance	-	Temperature/Cure
	Cracks				Broken/Damaged	_	•	on incomplete	L	Part Incorred	t	-	Weld
	Crushe	d/Crimped	1		Burrs	Ins	truct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs			1	Contamination	I IMa	ainte	nance	l	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

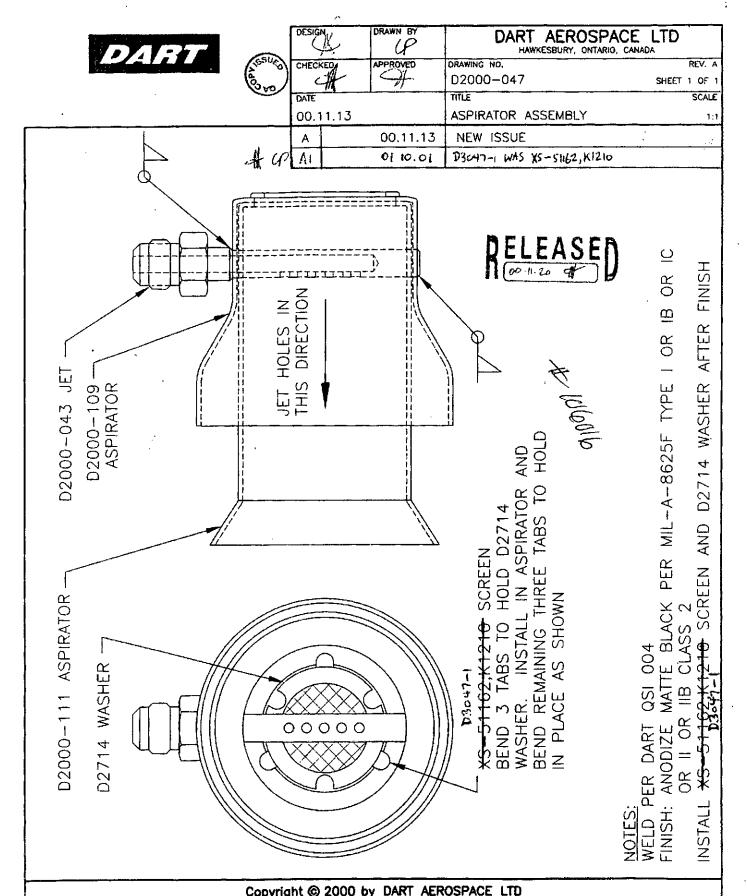
Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion



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A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62607

Date: 06-Sep-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

		,	Pn: 613-632-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Dana in the				
Quantity	Description				
1	Part: ASST	_	Rev:		
lot					
(,	2 PCS D2000-047				
	30 PCS BLACK ANODIZE	•			
	MIL-A-8625 TYPE II CLASS 2				
				•	
	29 PCS 647.9314				
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2				
	MIL-A-0023 TIPE III CLASS 2				
	PRIME MIL-P-23377 J TYPE I CLA	ASS N			
	Job: 20130555	PO: 21136	Line:		
	Certificate of Co	nformance			
	A.T.G. Industries certifies that all items with all requirements, specifications an	in this shipment are d drawings reference	in conformance		
			or in the parenase order.		
	ISO 9001 : 2008 RE ATG SALES-2010 TI	GISTERED FRMS APPLY			
	1/0/2				
	DATE: 6/7//3				
	M	h			
	CERTIFIED SIGNATURE :				
	RECEIVER SIGNATURE :				
					
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